

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021676**Date Inspected:** 22-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 8 ZPMC was in process of FCAW (ESAB) welding on bike path assembly BK004A6-062. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK004A6-062-072, 073

WPS-B-T-2132-ESAB

Welder-054459

2F/FCAW

This QA inspector observed ZPMC personnel performing Heat Straightening (HSR1 B 10101) on traveler rail bike path assembly BK004A2-063-014, 015, 017, 019, 020. ZPMC CWI inspector Lui Fa Wen was present at this time of this observation and informed this QA inspector of the work that is in process.

Bay 3

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This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 3 ZPMC was in process of FCAW (ESAB) welding on Architectural Housing subassembly AH3150. ZPMC CWI inspector Wang Liang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- EP3017—001-014, 015

WPS-B-P-2113

Welder-068091

3F/FCAW

Bay 1

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of FCAW (ESAB) welding on traveler rail assembly. ZPMC CWI inspector Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 2 welders performing weld repairs and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR22057

Weld- 9TR-001-020, 017, 018

WPS-345-FCAW-2G(2F)-ESAB-Repair

Welder-217185

2G/CJP/FCAW

WR22058

Weld- 9TR1-002-017

WPS-345-FCAW-2G(2F)-ESAB-Repair

Welder-053609

2G/CJP/FCAW

WR22056

Weld- 9TR2-001-002, 017, 008

WPS-345-FCAW-2G(2F)-ESAB-Repair

Welder-053609

2G/CJP/FCAW

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 10 ZPMC was in process of SMAW welding on Tower Head Cover subassembly. ZPMC CWI inspector Zhao Chan Sun was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

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Weld- SSD1-TPSA6-7
WPS-B-T-2312-TC-P4
Welder-500363
2G//SMAW/PJP

This QA inspector observed during the observation that at Bay 10 ZPMC was in process of FCAW (ESAB) welding on bike path assembly BK009A4. ZPMC CWI Guo Yan Fei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK009A4-013, 014
WPS-B-T-2132-ESAB
Welder-052075, 053869, 040302, 040533
2F/FCAW

This QA inspector observed during the observation that at Bay 10 ZPMC was in process of FCAW (ESAB) welding on bike path cantilever beam assembly BK15B. ZPMC QC inspector Jiang Xiao Bo was present at this time of this observation and informed this QA inspector of the work that is in process and Zhao Chen Sun as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK015B-001-023 ~ 026
WPS-B-T2133-ESAB
Welder- 054069
3F/FCAW

Bay 11

This QA inspector observed ZPMC in process of SMAW welding on traveler rail assembly 20TR2-034. ZPMC QC inspector Wang Chuang Xin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhao Chen Sun as the CWI. It was stated that ZPMC had 1 welder performing tack welding web to flange and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-034-017
WPS-B-P-2214-TC-U5
Welder- 220046
4G/SMAW/CJP

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Trial Assembly ZPMC was in process of welding on 12BW+12CW. ZPMC QC inspector Hu Mei Gang was present at this time of this observation and informed this QA inspector of the work that is in process and

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identified Zhu Zhong Hai as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20193

Weld- OBW12E-001

WPS-345-SMAW-3G(3F)-FCM-Repair

Welder-040611

3G/SMAW/CJP

Weld- Fit-up Aids

12BW+12CW Longitudinal Diaphragm BK side

Welder-044574

2F, 3F/SMAW/Tack Weld

This QA inspector observed ZPMC welding on 12AE/ CB17. ZPMC CWI Zhu Zhong Hai was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- FB3031-001-017, -18, 019, 020

WPS-B-P-2114-FCM-1

Welder-052493

4F//SMAW

Weld- FB3039-001-017, -18, 019, 020

WPS-B-P-2114-FCM-1

Welder-044504

4F//SMAW

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Hasler, Mike

Quality Assurance Inspector

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Reviewed By: Riley, Ken

QA Reviewer